

Date: Wednesday, 27/02/2008 7:40:22 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET L/H
Job Number : 37635
Estimate Number : 11549
P.O. Number :
This Issue : 27/02/2008 S.O. No. :
Prsht Rev. : NC Part Number : D30721
Drawing Number : D3072 REV A1
First Issue : / / Type : SMALL /MED FAB Project Number : N/A
Drawing Revision : A1
Previous Run : 37635 Material :
Due Date : 14/03/2008 Qty: 20 Um: Each
Written By :
Checked & Approved By :
Comment : Est. B02.01.18 Flat pattern created on dash 101. NG
Est Rev:C 08-02-26 now water jet DD verified by:LL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S090 5052-H32 .090 Sheet



Comment: Qty.: 0.1225 sf(s)/Unit Total : 2.4507 sf(s)

5052-H32 .090 Sheet

Batch 3019 B 8-2-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3072 (D3072-101 flat pattern)

Dwg Rev: A1 B 8-2-27

Prog Rev: A1

2-Deburr if necessary B 8-2-27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- deburr if necessary

2- Bend as per dwg D3072

B 08/03/04 (21)

8B 08/03/03

PFD 3 pages

(21)

Date: Wednesday, 27/02/2008 7:40:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET L/H

Job Number: 37635

Part Number: D30721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (21)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL

08-03-05

(21)

8.0

POWDER COATING

POWDER COATING



M100700



(21X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1

08/03/06

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-03-06

(21)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5763

EC 45/3

(21)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/03/06

(21)

Job Completion



2008/3/06

(21)

Date: Tuesday, 2/26/2008 8:02:16 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
Job Number : 37635
Estimate Number : 11549
P.O. Number :
This Issue : 2/26/2008 S.O. No. :
Prsht Rev. : NC Part Number : D30721
First Issue : 1 / 1 Type : SMALL / MED FAB Drawing Number : D3072 REV A1
Previous Run : Project Number : N/A
Written By : Material :
Checked & Approved By : Due Date : 3/14/2008 Qty: 20 Um: Each
Comment : Est. B 02.01.18 Flat pattern created on dash 101. NG

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3072101 Bracket (flat)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bracket (flat)

Pick:

Qty	Part Number	Description	Batch
1	D3072-101	Bracket	

W. H. H. H.

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend as per dwg D3072

Dash 1 bending detail(LH)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0 POWDER COATING POWDER COATING



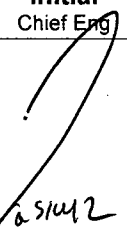
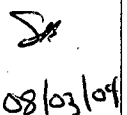
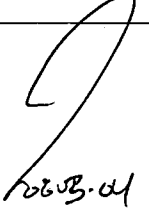

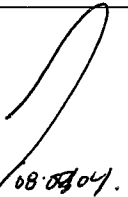
Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/04	5	1 putz was out of tolerance Hence error	 08/03/04	Scrap + destroy No replace	 08/03/04	 08/03/04	 08/03/04	 08/03/04

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:02:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37635

Part Number: D30721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

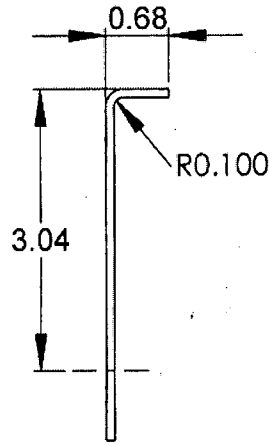
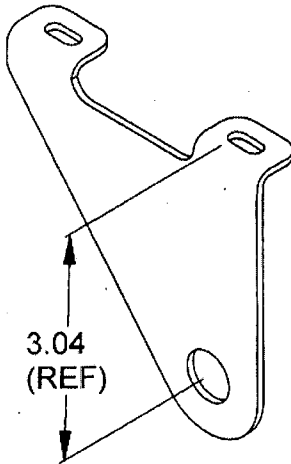
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3072	REV. A SHEET 1 OF 1
DATE 01.12.16	TITLE BRACKET	SCALE 1:1	
A	01.12.16	NEW ISSUE	
A1 02-01.18		ADD FLAT PATTERN PART NUMBER # CP	



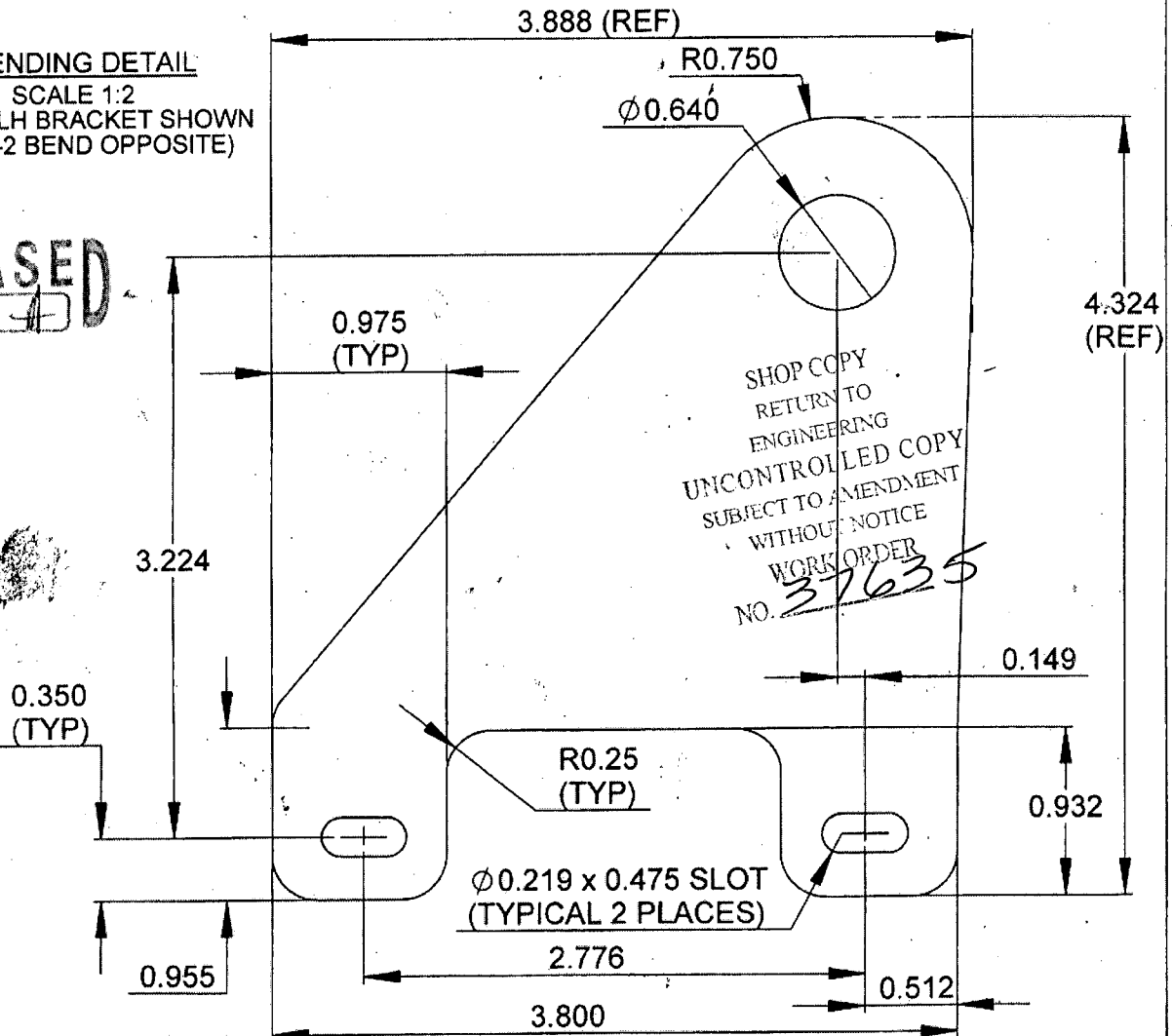
D3072-1/-2 BRACKET

- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COATBLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL

SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02-01-15



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37635



D3072-101
FLAT PATTERN FOR D3072-1/-2

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